User:

Tuesday, 15/08/2006 7:56:32 AM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 28105

Estimate Number P.O. Number

This Issue

: 15/08/2006

S.O. No. : NA

: NC

Prsht Rev. : 10/08/2006 First Issue

: 24680

Previous Run Written By

Checked & Approved By

Comment

: Est

A03.01.15

: PURCHASED PARTS

Part Number

Drawing Name

: D31263

Drawing Number

D3126 REV A1 : N/A

: BRACKET

Project Number Drawing Revision

Material **Due Date** NUT : 30/08/2006

20 Um:

Each

Additional Product

Job Number:



Seq. #:

Description:

304/316 .032 Sheet

FLOW WATER JET

1.0

M304S22GA

Total: 1.1780 sf(s) 0.0589 sf(s)/Unit

304/316 .032 Sheet

0084

2.0

WATER JET

Comment: FLOW WATER JET

Comment: Qty.:

3.0

QC2

PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D3126-3T1

5.0

NC BRAKE



Comment: NC BRAKE

Deburr if necessary Form on CNC brake as per D3126 using Jig D3126T1Identify as D3126-3

Scribe Dart P/N as shown on Dwg D3126

Page 1

Form: rprocess

Date: **以**ser:

Tuesday, 15/08/2006 7:56:33 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28105

Part Number: D31263

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1

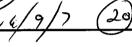


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_

DOCUMENT CONTROL



8.0

DC



Comment: DOCUMENT CONTROL Inspection Level 21

Job Completion



h 06-9-07

Each

Dart Aerospace Ltd. Thursday, 10/08/2006 9:56:00 AM Linda Lacelle User: **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name BRACKET** Customer Job Number : 28105 : 10739 **Estimate Number** : D31263 **Part Number** P.O. Number - D3126 REV A1 : 10/08/2006 S.O. No. : **Drawing Number** This Issue : NC : N/A **Project Number** Prsht Rev. : // : PURCHASED PARTS **Drawing Revision** First Issue Type : 24680 Material **Previous Run** 20 Um: **Due Date** 30/08/2006 Qty: Written By Checked & Approved By Comment **Additional Product** Job Number: Description: Seq. #: **PURCHASING** 1.0 PG M100843 **Comment: PURCHASING** Issue P/O: Email or ship Dxf file to vendor Laser cut per Dwg D3126 flat patern D3126-3 Material: AISI 304/316 SS sheet 0.032" thick per MIL-S-5059(Ref: Material release note required Bracket-Flat 2.0 D31263F 1.0000 Each(s)/Unit Total: 20.0000 Each(s) Comment: Qty.: **Bracket** PACKAGING RESOURCE #1 3.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Receive and Inspect for transit damage Ensure the material note is attached. DIMENSIONAL CHECK 4.0 QC6

Comment: DIMENSIONAL CHECK

Inspect dimensions per template D3126-3T1

BRAKE NO NC BRAKE 5.0

Comment: NC BRAKE

Deburr if necessary

Form on CNC brake as per D3126 using Jig D3126T1Identify as D3126-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					-				
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:			
			QA: I	N/C Close	d:	Date: _			

	WORK ORDER NON-CONFORMANCE (NCR)								
Description	Description of NC		Corrective Action Section B			Ammount			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
	STEP	STEP Description of NC Section A	STEP Section A Initial	STEP Section A Initial Action Description	STEP Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Section A Initial Action Description Sign & Verification Approval		

NOTE: Date & initial all entries

Date: User: Thursday, 10/08/2006 9:56:01 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28105

Part Number: D31263

Job Number:



Seq. #:

Machine Or Operation:

Description:

Scribe Dart P/N as shown on Dwg D3126

6.0

QC5

INSPECT WORK TO CURRENT STEP





Comment: INSPEC WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

8.0

DC

DOCUMENT CONTROL





Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr Approva QC Inspector						
												
Part No		PAP #: Fault Category:	NCP: Voc	No DO	۸.	Data						

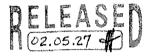
Part No):	PAR #:	Fault Cate	gory: N	CR: Yes N	o DQA:	_ Date: _	
					QA: N/0	Closed:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

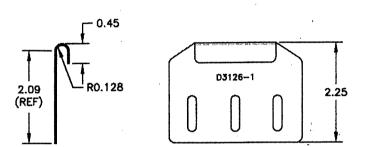
Section A	Chief Eng	Chief Eng	Date	Section C	Ciller Ling	QC IIIspector
					ì	
						1

NOTE: Date & initial all entries

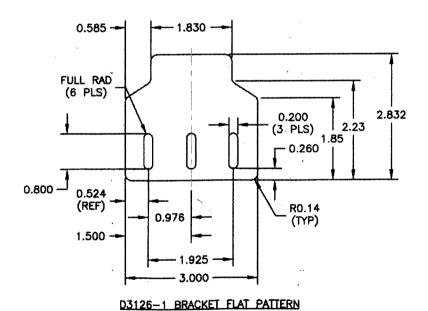


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	CHEC	(ED _M)	APPROVED	DRAWING NO.	REV. A
,		#	4	D3126	SHEET 1 OF 3
	DATE		A	ΠLE	SCALE
	02.0)4.17		BRACKET	1:2
ζ.	Α		02.04.17	NEW ISSUE	
	Ai	104	02.09.23	ADD "ANNEALED" SPEC	





D3126-1 BRACKET
REPLACES PREMIER P/N B30-23000-265



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 5) SCRIBE DART P/N D3126-1 AS SHOWN

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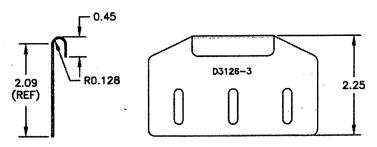
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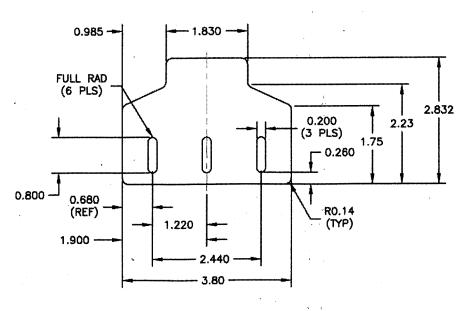
DESIGN #	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	D3126	REV. A SHEET 2 OF 3
DATE		TITLE	SCALE
02.04.17		BRACKET	1:2

.





<u>D3126-3 BRACKET</u> REPLACES PREMIER P/N B30-23000-267



D3126-3 BRACKET FLAT PATTERN

NOTES

- MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES 0.005 TO 0.010 SCRIBE DART P/N D3126-3 AS SHOWN

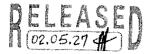
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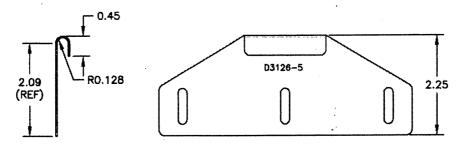
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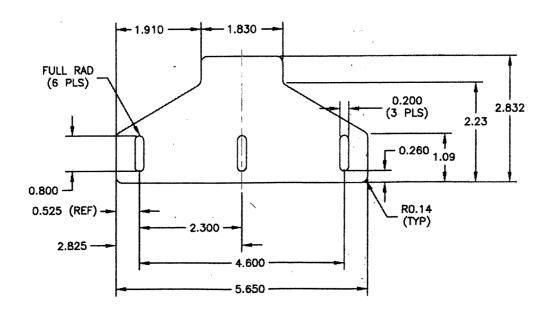


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CHECKED	APPROVED	DRAWING NO.	REV. A
#	1	D3126	SHEET 3 OF 3
DATE		TITLE	SCALE
02.04.17		BRACKET	1:2





D3126-5 BRACKET
REPLACES PREMIER P/N B30-23000-269



D3126-5 BRACKET FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
 2) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) SCRIBE DART P/N D3126-5 AS SHOWN

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DART AEROSPACE LTD	Work Order:	28102
2		0.0/ -2
Description: DRACKOT	Part Number:	3126-3
A		Page 1 of 1
Inspection Dwg: Rev:		

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.830	+1-0.010	1.836	V	,	VERN	
2.839	7 . \\	2.836			VRPN	
3.80	4-0.030	3.807	V		vern	
0.200	t1-0.010	0.195	√		VLFN	
0.800	+1-0.010	0.806	· V		verN	4.
0.260	11-0.010	0.259	✓		verN	
1.75	H- 0.030	1.769	V		VLVW	
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Measured by: M M	Audited by:		Prototype Approval:	
Date: 05.07.17	Date:	66-08-20	Date:	

Day	Date	Change	Revised by	Approved
Rev	Date		KJ/JLM	
l A		New Issue		

